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February 13, 2004

Our reference: 8443WO – WEB

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Process For Manufacturing Bags

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Claims

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1. Process for manufacturing a bag (25, 40) from a polymer and/or metal film material,  
wherein the lower end of the bag (25, 40) is sealed and the bag comprises of four outer walls (A-D) that are connected by four seams (27),  
**characterized in that**

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the material required for forming the bags (A-E) is fed in the form of a film tube (25, 40) that is wound up on a roll to the unwinding station of a bottom forming device that separates the unwound film tube into film tube segments and seals at least one end of the bag.

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2. Process pursuant to claim 1,  
**characterized in that**  
a film tube (25) is used that already comprises side gussets (26).

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3. Process pursuant to one of the aforementioned claims,  
**characterized in that**  
the bottom of the bag is formed using transverse sealing.

4. Process pursuant to the preceding claim,

characterized in that

the bottom of the bag is formed exclusively by a squeezing process and a transverse sealing process.

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5. Process pursuant to one of the aforementioned claims,

**characterized in that**

the bottom formation of the bag is followed by a filling process of the bags.

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6. Process pursuant to one of the aforementioned claims,

**characterized in that**

the top end of the bags is also sealed using transverse sealing.

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7. Process pursuant to one of the aforementioned claims,

**characterized in that**

the bag is formed and filled partly in a form, fill and seal machine.

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8. Process pursuant to one of the aforementioned claims,

**characterized in that**

a film tube (25, 40) is used in which at least one part of the four seams of the film tube is formed by a joining process in which additional joining material, such as adhesives or extrudates, is applied on the seam (27).

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9. Process pursuant to one of the aforementioned claims,

**characterized in that**

a film tube (25, 40) is used that is formed out of four film webs (A-D) that are fed parallel to one another by film supply devices to a joining station (8).

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10. Process pursuant to the preceding claim,

**characterized in that**

the conveying direction of the four film webs to the joining station (8) defines the longitudinal axis of the formed film tube (25, 40).

- 5      11. Tubular film roll (36) formed out of a film tube with four side walls (A-D) that are joined to one another using four seams (27).
12. Tubular film roll (36) pursuant to claim 11,  
10      **characterized in that**  
two (BC) of the four side walls (A-D) have side gussets (26).
13. Tubular film roll (36) pursuant to claim 12,  
15      **characterized in that**  
the front sides (A, D) of the side-gussetted film tube (25) lie over one another.
14. Tubular film roll (36) pursuant to claim 12 or 13,  
    **characterized in that**  
the side gussets (26) are staved toward the direction of the tube axis.